

Work Order ID 133784

Wednesday, June 17, 2015 2:51:57 PM

133784

U/R

Page 1

Item ID: D3883-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: ~~D3883~~ *N/A* Stop ***NS2***
 Item Name: Saddle, Outboard LH
 Start Date: 6/17/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 6/17/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: JUN 17 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3883	D								

100 HAAS CNC VERTICAL MACHINING #1 0.00
100
 HAAS 1
 HAAS CNC vertical machine #1

Memo
 Program Batch No. 133784
 Double check by: SL
 1-Machine Step No 1 per Folio FA815 and inspect per attached Dimension
 Sheets
 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA815 and inspect per Dimension Sheets

MILL AS PER DWG AND FOLIO FA815
 FOLIO REV: AA
 DWG REV: D

105 0.00
105
 Mill Conv
 Conventional Milling Machine

Memo
 MILL KEYWAY AS PER DWG

8 SL 15-6-10

8 SL 15-6-10

Wednesday, June 17, 2015 2:51:57 PM

Item ID: D3883-1

Accept

N900040100

Setup Start *NS1*

Revision ID: U/R

Item Name: Saddle, Outboard LH

Stop *NS2*

Start Date: 6/17/2015 **Start Qty:** 8.00

8

Cust Item ID:**Required Date:** 6/17/2015 **Req'd Qty:** 8.00

8

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

Wednesday, June 17, 2015 2:51:57 PM

Page 3

Setup Start *NS1*

Cust Item ID:

Stop *NS2*

8

g

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

Memo *14* 131545.

0.00

***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF
POWDER COAT AS PER INDICATED ON DWG (SEE NOTE 2)***

DO NOT MASK INSIDE FLANGE SURFACE

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

Memo

0.00

DAS
38
9-89

Quality Control

JUL 21 2015

Work Order ID 133784

Wednesday, June 17, 2015 2:51:57 PM

133784

Page 4

Item ID: D3883-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: U/R Stop ***NS2***
 Item Name: Saddle, Outboard LH
 Start Date: 6/17/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 6/17/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>St 404</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

8 JUL 21 2015

MLJ JUL 22 2015

MLJ JUL 21 2015

Picklist Print

Wednesday, June 17, 2015 2:52:01 PM

Page 1

Work Order ID: 133784

133784

Parent Item: D3883-1

D3883-1

Parent Item Name: Saddle, Outboard LH

Start Date: 6/17/2015

Required Date: 6/17/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC
15.05.20 remove inside powdercoat DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-015		Manufactured	No			100	Each	2.0000	1	8			
D6101-015									**			15/07/08	DAS
Saddle Billet													40
													9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	1	
129885	1	
MAT045	1	
124323	1	

→ 133454

8

DART AEROSPACE LTD		Work Order:	133784
Description: Saddle, Outboard, LH		Part Number:	D3883-1
Inspection Dwg: D3883	Rev: C1		
		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.648	0.646	0.648	0.648		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.258	0.258	0.258	0.258		
F	0.605	0.625		0.625	0.616	0.616	0.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.002	2.003	2.004	2.005		
J	0.140	0.165		0.150	0.151	0.149	0.148		
K	0.240	0.260		0.252	0.250	0.249	0.249		
L	0.115	0.135		0.121	0.125	0.125	0.126		
M	0.140	0.165		0.149	0.150	0.149	0.149		
N	0.720	0.780		0.780	0.780	0.780	0.780		
O	0.240	0.260		0.251	0.247	0.250	0.250		
P	0.110	0.140		0.140	0.140	0.140	0.140		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	2.825	2.885		2.860	2.860	2.860	2.860		
S	0.316	0.321		0.316	0.316	0.316	0.316		
T	0.990	1.010		1.000	0.999	1.000	1.000		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.001	6.000	6.000	6.000		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		0.503	0.499	0.500	0.499		
Y	1.220	1.280		1.260	1.260	1.260	1.260		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		0.313	0.313	0.313	0.313		
AB	0.020	0.040		0.025	0.025	0.025	0.025		
AC	0.760	0.765		0.760	0.760	0.760	0.760		
AD	0.215	0.220		0.217	0.217	0.218	0.217		
AE	1.265	1.285		1.268	1.269	1.269	1.270		
AF									
Accept/Reject									

Measured by:	SL
Date:	15-7-9

Audited by:	FR
Date:	15/07/15

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	

DART AEROSPACE LTD		Work Order:	133784
Description: Saddle, Outboard, LH		Part Number:	D3883-1
Inspection Dwg: D3883	Rev. 01	Page 1 of 1	

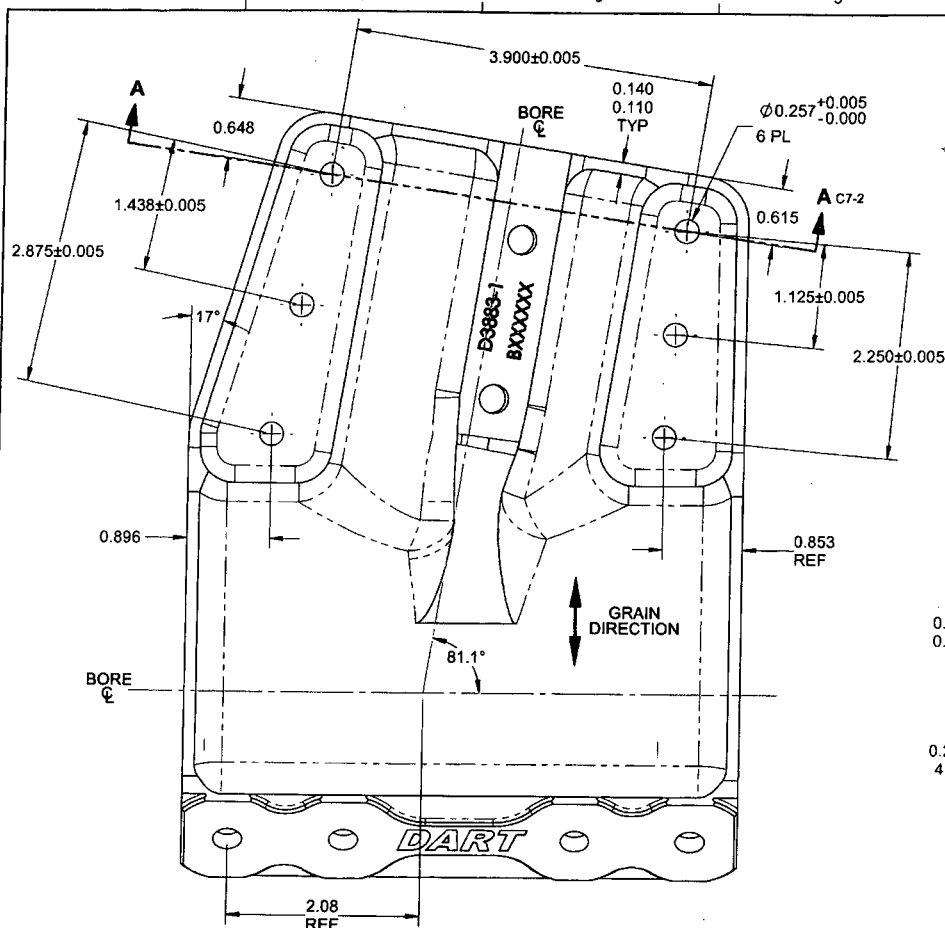
Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.649	0.647	0.646	0.646		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.258	0.258	0.258	0.258		
F	0.605	0.625		0.612	0.615	0.616	0.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.003	2.005	2.005	2.005		
J	0.140	0.165		0.149	0.148	0.148	0.148		
K	0.240	0.260		0.249	0.247	0.249	0.250		
L	0.115	0.135		0.124	0.125	0.125	0.124		
M	0.140	0.165		0.149	0.148	0.148	0.148		
N	0.720	0.780		0.720	0.780	0.780	0.780		
O	0.240	0.260		0.249	0.250	0.250	0.252		
P	0.110	0.140		0.140	0.140	0.140	0.140		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	2.825	2.885		2.860	2.860	2.860	2.860		
S	0.316	0.321		0.316	0.316	0.316	0.316		
T	0.990	1.010		1.000	1.000	1.000	1.000		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		0.499	0.500	0.500	0.500		
Y	1.220	1.280		1.260	1.260	1.260	1.260		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		0.313	0.313	0.313	0.313		
AB	0.020	0.040		0.025	0.025	0.025	0.025		
AC	0.760	0.765		0.760	0.760	0.760	0.760		
AD	0.215	0.220		0.218	0.218	0.218	0.218		
AE	1.265	1.285		1.268	1.270	1.270	1.270		
AF									
Accept/Reject									

Measured by:	SL
Date:	15-7-9

Audited by:	FK
Date:	15/07/15

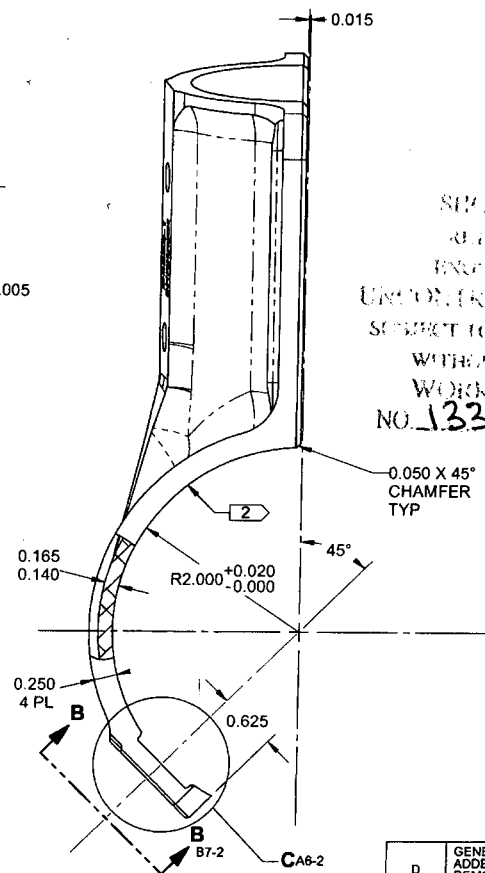
Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	



D3883-1 SADDLE, OUTBOARD LH

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3883-1-REVD.SLDPRT"



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 133784 MLJ

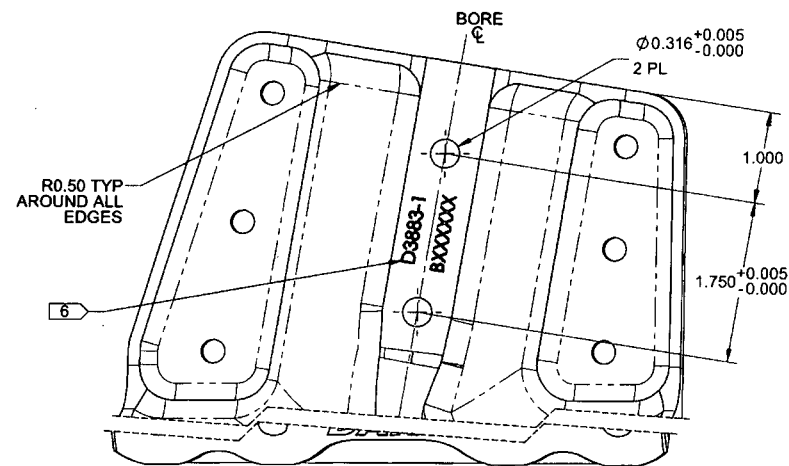
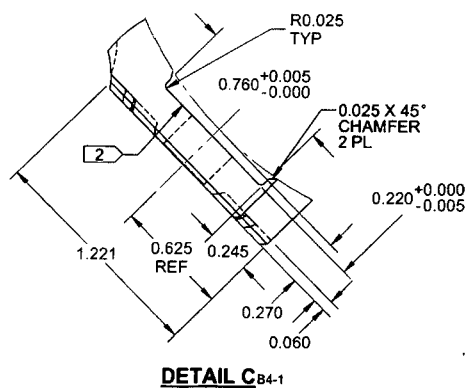
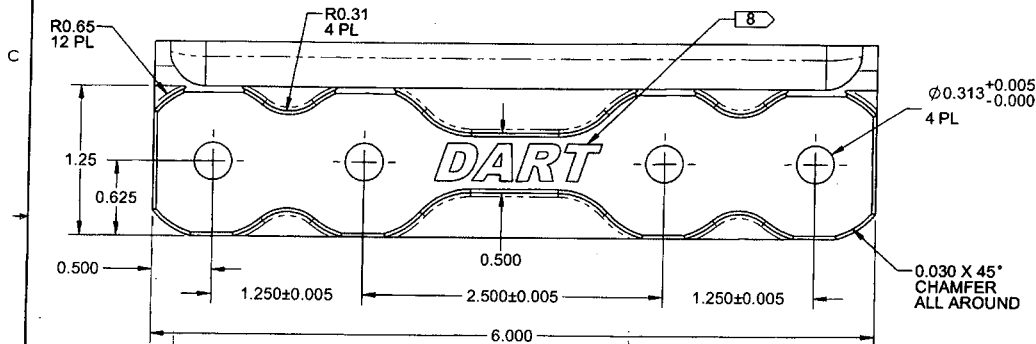
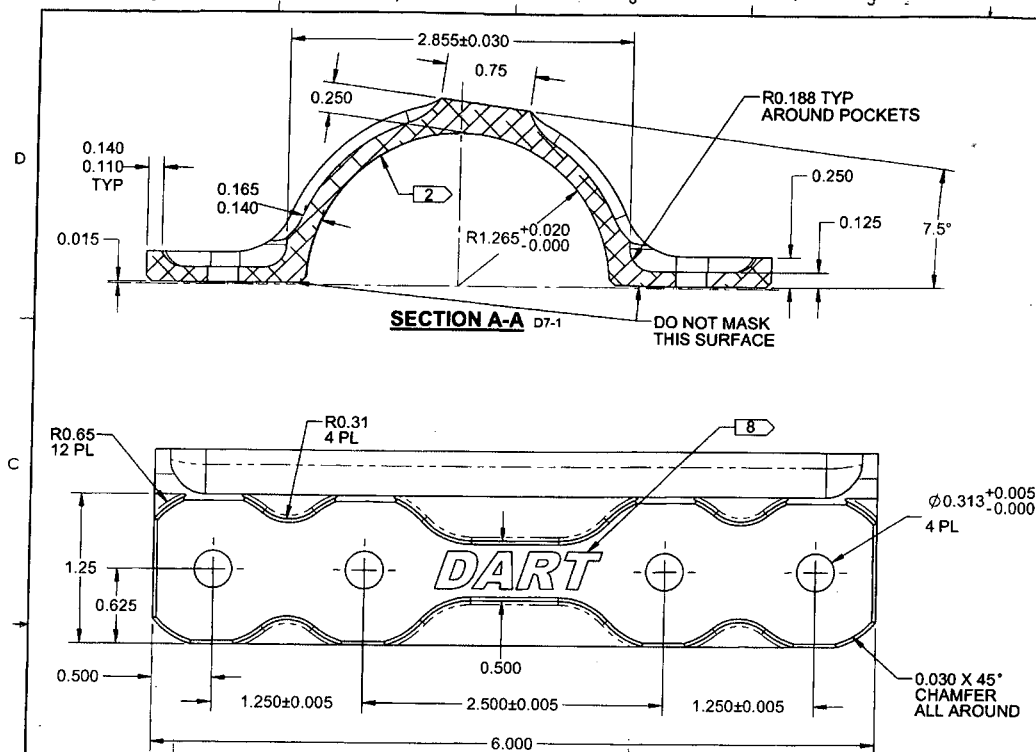
15-06-17

RELEASED

2015 MAY 19
A.P. ECHNIS-575

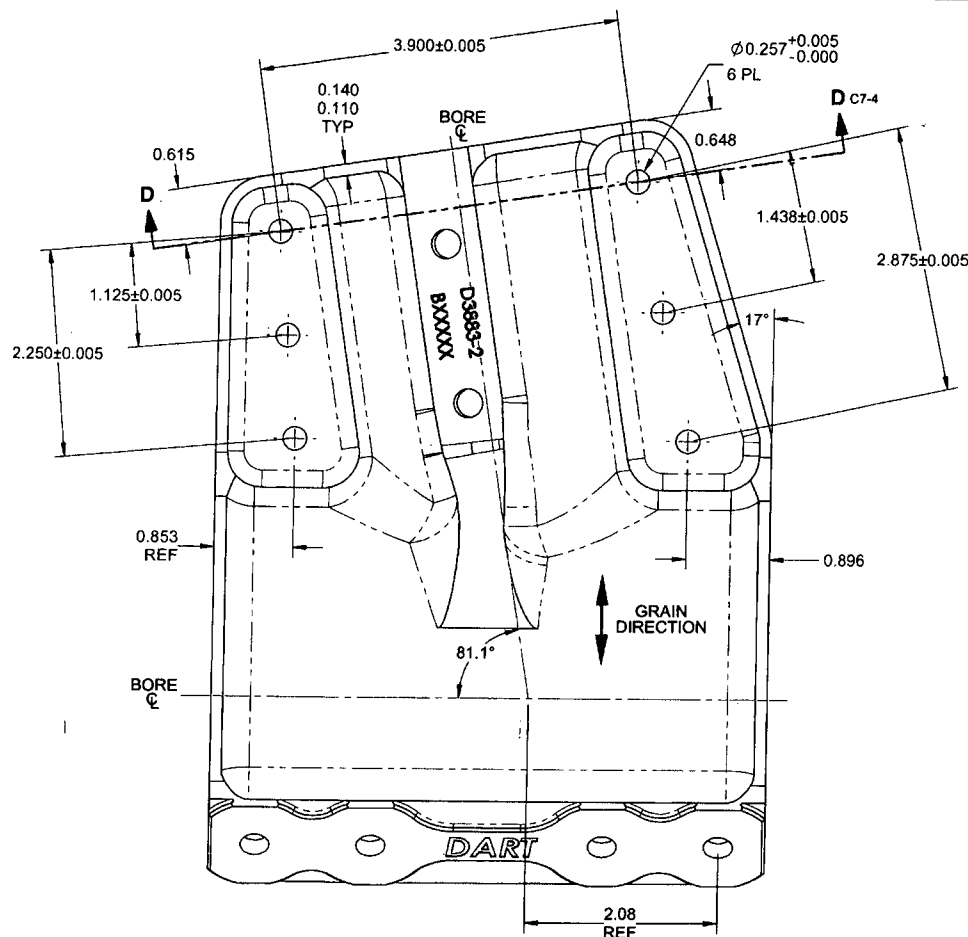
D	GENERAL REDRAW, ADDED D3883-2 ON SHEETS 3 & 4, ADDED NOTE 9 & REMOVED UNNECESSARY DIMS, REMOVED POWDER COAT ON INSIDE SURFACE OF D3883-1/2	AP	15.02.11
C	ADD R1.285 (ZN D6-2)	RF	09.11.09
B	D6101-015, ZN A7-1; ADD 0.648, ZN D7-1; ADD 0.615, ZN D6-1; ADD 0.125, ZN D7-2; ADD 0.060 & R0.031, ZN B5-2; 0.75 WAS 0.728, ZN C7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO. REV. D	
MFG. APPR.	JLM	D3883 SHEET 1 OF 4	
APPROVED	HS	TITLE SCALE	
DE APPR.	DS	OUTBOARD SADDLE NTS	
DATE	15.02.11	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED



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A.R. 2015 MAY 19

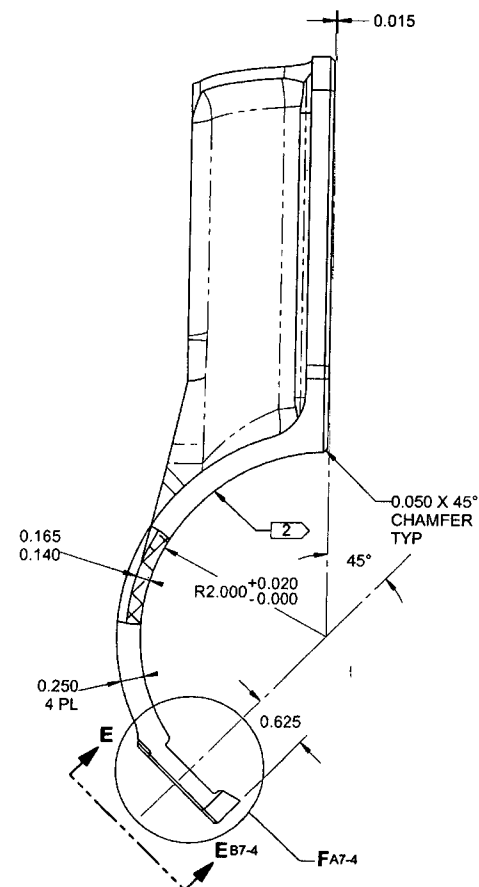
APPROVED	DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D3883	SHEET 2 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD SADDLE	NTS
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D3883-2 SADDLE, OUTBOARD RH

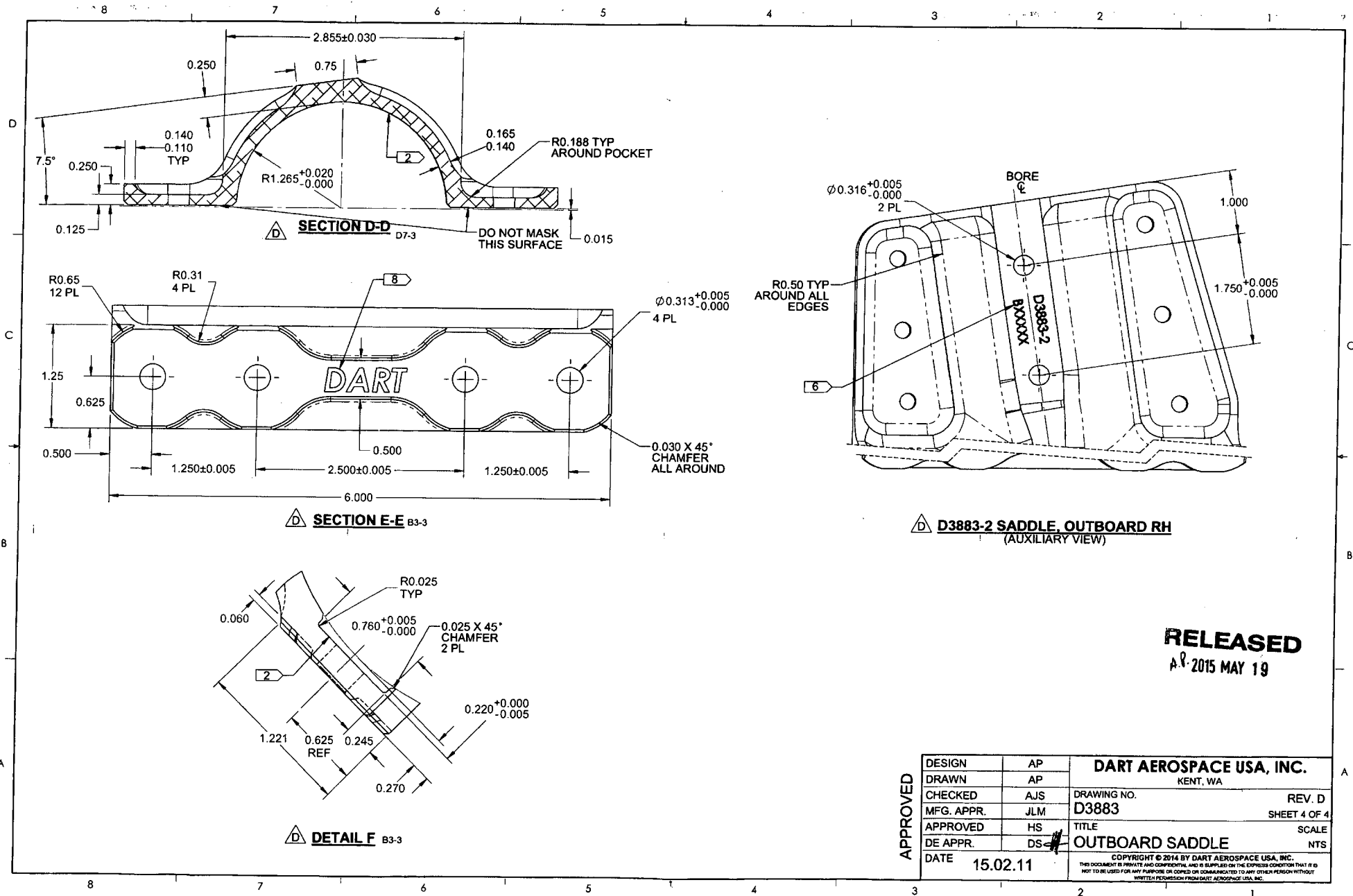
NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3883-2-REV.D.SLDPRT"



RELEASED
A.P. 2015 MAY 19

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D3883	SHEET 3 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD SADDLE	NTS
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APR 2015 MAY 19

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	DRAWN	AP	KENT, WA	
	CHECKED	AJS	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D3883	SHEET 4 OF 4
	APPROVED	HS	TITLE	SCALE
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